

## INSTRUCTIONS FOR FITTING CROSS-CUT SAWS WITH SAW TOOL

**JOINT THE SAW** — Clamp an eight-inch file on edge in the frame of the saw tool and adjust the clamping screw to curve the file to suit the curvature on the tips of the saw teeth. Then with the lugs of the frame resting against the flat surface of the saw pass the curved surface of the file over the tips of the cutting teeth until all of them are jointed to a uniform height. See illustration No. 1.

**FILE THE RAKER TEETH** — Apply the saw tool frame to the flat of the saw with the lower surface of the flanged edge resting on the tips of the cutting teeth and with a raker tooth projecting through the slot in the gauge block. File the tips of the raker tooth to the level of the gauge block. Repeat until all raker teeth have been filed. See illustration No. 2.

As supplied, the top surface of the gauge block is  $\frac{1}{16}$  inch below the flange surfaces against which the cutting teeth make contact during this operation. The height of the gauge block surface may be changed by changing the cardboard shim between it and the frame. The raker teeth should be  $\frac{1}{16}$  inch shorter than the cutting teeth for soft and medium-hard woods, and  $\frac{1}{8}$  inch shorter for hard woods.

**SET THE CUTTING TEETH** — Place the setting block on a log, stump, or block of wood. Drive in the spur, and if desired secure the block more firmly with a nail or screw driven through the slot in the end of the block. Lay the saw on the block with the points of the cutting teeth projecting over the bevel and strike each tooth two or three blows with a light hammer. See illustration No. 3.

Gauge the set with the set-gauge by applying three of its points to the flat of the saw and the fourth point to the tip of each cutting tooth. Either the short end or the long end of the set-gauge may be applied to the tooth according to the amount of set desired. The short end provides for the smaller amount of set, and the long end for a greater set. The points of the set-gauge may be filed to regulate the amount of set that the gauge will measure. See illustration No. 4.

A wrench or "spring set" may be used to adjust and equalize the set of the teeth as they are set with the hammer and setting block. However, such tools should be used as little as possible and only to correct and adjust the work as it comes from the setting block — never to set the teeth originally.

**SWAGE THE RAKER TEETH** — Tap each point of each raker tooth with a light hammer to produce a slight hook at the aid. All raker teeth should be swaged or hooked to the same extent.

**FILE THE SAW** — Observe carefully the manner in which the saw is filed when new, and duplicate the original filing as nearly as possible.

**SIDE-FILE THE SAW** — Clamp an eight-inch file in the saw tool frame flatwise between the square nut on the clamping screw and the lugs provided to bear upon the edge of the file opposite the nut. With the frame serving as a holder pass the center of the exposed flat face of the file lightly over the sides of the teeth to remove burrs left after filing and to equalize minor irregularities in the setting. See illustration No. 5.

Do not side-file more than absolutely necessary to remove burrs, feather edges, and very slight irregularities in setting. Reset any teeth from which side-filing would actually remove stock, or which the side-file fails to touch.

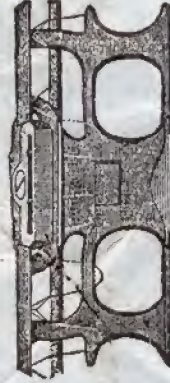
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NO. 1



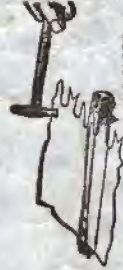
JOINTER.

NO. 2



RAKER TOOTH GAUGE.

NO. 3



SETTING BLOCK.

NO. 4



SET GAUGE.

NO. 5



SIDE FILE.